

539




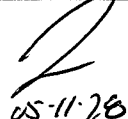
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24203
<b>Description:</b> Nut Plate	<b>Part Number:</b>	D2680-041
<b>Dwg:</b> D2680 Rev. <i>EBI</i>	<b>Qty:</b>	<del>100</del> 111
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler	AR	05/09/06	20												
2	PG	Issue P/O: <u>2008659</u> Email or Ship DXF file to vendor Laser Cut flat pattern as per Dwg D2680 Possible Supplier: GFI or Industrial Laser Material release note is required	AR	05/09/15	20												
3	RG	Receive and Inspect for transit damage Enure material release note is attached	DL	05/10/17	113												
4	QC6	Inspect dimensions as per Dwg D2680	2	05/11/14	113												
5	GA	Deburr	DL	05/11/21	111												
6	GA	C'sink as per Dwg D2680	DL	05/11/21	111												
7	FP	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05/12/29	111												
8	QC3	Inspect Powder Coat	DL	06/01/10	111												
9	GA	Install Nut plate as per Dwg D2680 Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>MS20426AD3-3</td><td>Rivet</td><td>M7681</td></tr><tr><td>1</td><td>MS21069L4</td><td>Nut Plate</td><td>M5865</td></tr></table> Identify as D2680-041	Qty	Part Number	Description	Batch	2	MS20426AD3-3	Rivet	M7681	1	MS21069L4	Nut Plate	M5865	DL	06/01/10	111
Qty	Part Number	Description	Batch														
2	MS20426AD3-3	Rivet	M7681														
1	MS21069L4	Nut Plate	M5865														
10	QC5	Inspect work to Step 9	2	06-02-11	111												
11	ST	Identify and Stock <div>Loc 57</div>	LC	06/01/16	111												
12	AC	Cost / part _____	SUR	06-01-17	111												
13	DC	Close W/O Inspect Level 21	LD	06/01/17	111												

Rev	Date	Change	Revised By	Approved
A	97.11.25	New issue		
B	99.01.04	Drawing to Rev.B	DM	
C	03.10.31	Reformat; Incorporated D2680-1	KJ/RF	
D	04.10.01	Added Steps 2-4, 7-8	KJ/JLM	

**RELEASED**  
*27/04/10-84*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-28	6	2 have crooked c'sink, oversizing holes.		Scrap: destroy	 05-11-28	2 05-11-28	 05-11-28	 05-11-28

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date &amp; initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/10/17

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

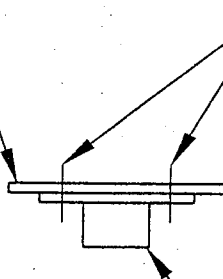


DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE SCALE 1:1		
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
BI	CP # 04.11.04	CHANGE HOLES & FINISH	

RELEASED  
98.12.14 DS

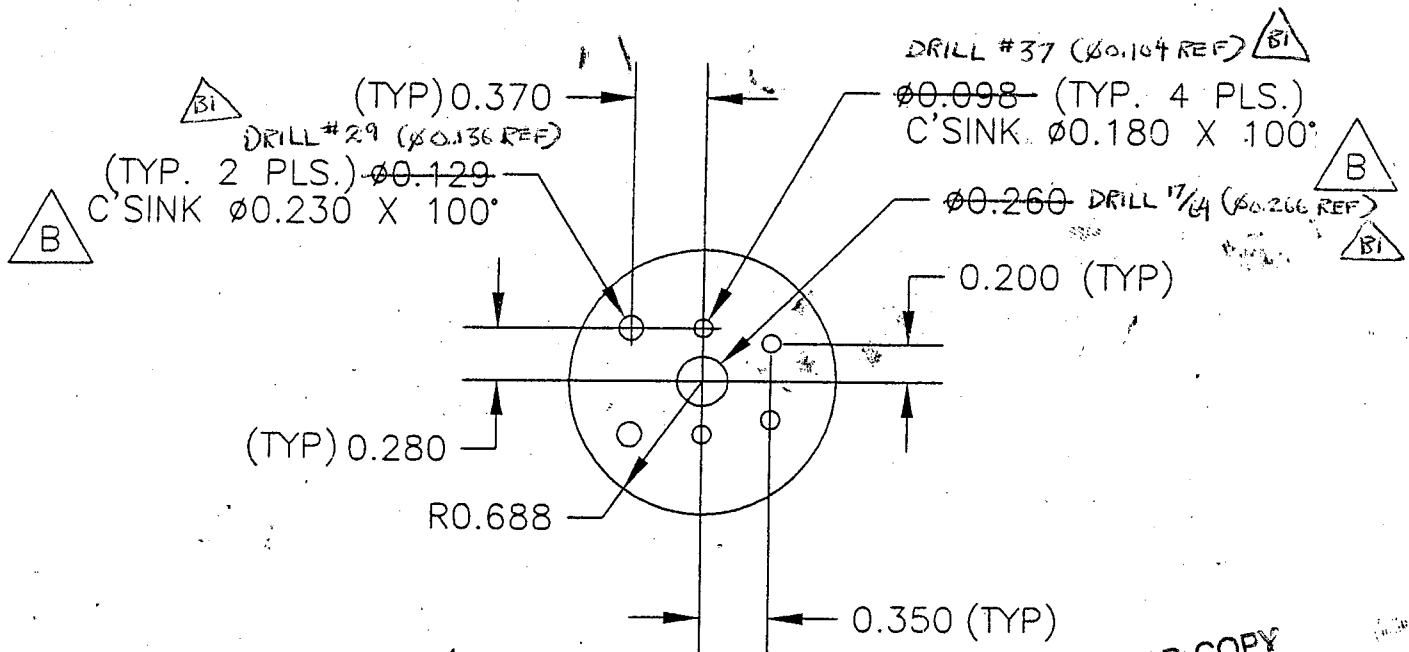
D2680-1

INSTALL WITH MS20426AD3-3  
RIVETS



MS21069L4 NUT PLATE.

D2680-041



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.063 THICK (16 GAUGE)

GAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

D2680-1

SHOP COPY

ENGINEERING

UNCONTROLLED COPY  
EXCISEMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 24203

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 02, 2005  
09:01 am

Work Order No : 0024203  
Project Name : D2680-041  
Project For : WK539  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2680-041  
Description : Nut Plate  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 09-01-05  
Est Finish Date : 09-29-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



P41123PC002

Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,  
Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No. 0035)  
Inspection Certificate EN10204-3.1B

# Taiyuan Iron and Steel(Group)Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China  
TEL: (0351)3013328 FAX: (0351)3017816  
http://www.tisco.com.cn  
E\_mail: tgbxg@tisco.com.cn

## INSPECTION CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	200412110	
DATE OF ISSUE	/ /	

CUSTOMER  
Marubeni-Itochu Steel CA.

CONTRACT NO.  
Y-947

DATA OF  
2004/12/20

Product Melting furnace Inspectors stamp Mark of the Manufacturer

COIL E-VOD  Shanxi Taiyuan Stainless Steel Co.,ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
1	4405025	4A11-303-12B	1	11GA x 48 x C	4358
2	4404509	4A10-356-12B	1	14GA x 48 x C	3920
3	QHLL0164	4A12-141-3ZJ	1	14GA x 48 x C	4972
4	Y408037	4A12-373-4ZD	1	12GA x 48 x C	4382
5	Y408037	4A12-374-4ZD	1	12GA x 48 x C	4347
6	Y408037	4A12-375-4ZD	1	12GA x 48 x C	4257
7	4405608	4A12-341-1ZJ	1	12GA x 48 x C	3793

### Chemical Composition

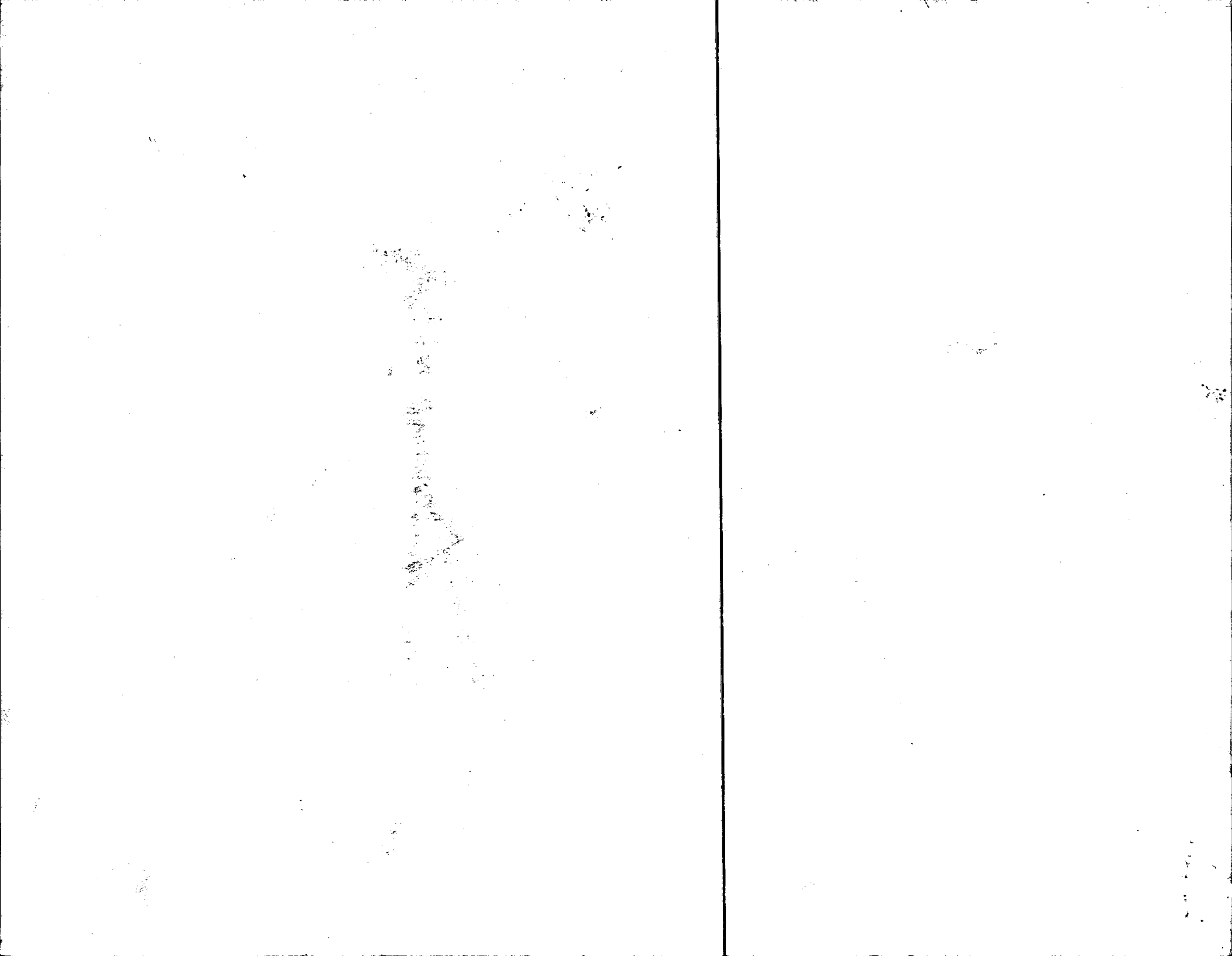
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4405025	0.060	0.470	1.340	0.020	0.002	18.050	8.100				0.059
4404509	0.050	0.470	1.350	0.021	0.002	18.080	8.120				0.060
QHLL0164	0.052	0.546	1.077	0.027	0.003	18.300	8.080				0.044
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
4405608	0.060	0.510	1.350	0.021	0.002	18.090	8.100				0.055

### Mechanical Properties

Test No.	Tensile R m N/mm <sup>2</sup>	R <sub>p0.2</sub> Yield <sub>0.2%</sub> N/mm <sup>2</sup>	R <sub>p1.0</sub> Yield <sub>1.0%</sub> N/mm <sup>2</sup>	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4405025-T	610	255		65		83		
4404509-T	655	265		61.5		84		
QHLL0164-T	660	275		58.5		83		
Y408037-T	660	260		64		85		
Y408037-T	660	260		64		85		
Y408037-T	660	260		64		85		
4405608-T	665	265		61.5		84		

Surface and dimensions controlled:

Work Inspector: 



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
11:10 am

Work Order No : 0024203  
Project Name : D2680-041  
Project For : WK539  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2680-041  
Description : Nut Plate  
Manufactured : Yes  
Amount Req'd : 100  
Amount Done : 0  
Start Date : 09-01-05  
Est Finish Date : 09-29-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	245.21	100.00	0.00	245.21
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	245.21	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	245.21			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -245.21)

MIS-2/B  
u  
11/15

Date: Tuesday, 15/11/2005 8:05:00 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	NUT PLATE
<b>Job Number</b> :	24203		
<b>Estimate Number</b> :	10316		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2680041
<b>This Issue</b> :	15/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2680 REV B1
<b>First Issue</b> :	//	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	B1
	<b>Type</b> :	<b>Material</b> :	
	PURCHASED PARTS	<b>Due Date</b> :	30/11/2005
<b>Written By</b> :		<b>Qty:</b>	100
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

1-Email or Ship DXF file to vendor

2-Laser Cut flat pattern as per Dwg D2680

3- Possible Supplier: GFI or Industrial Laser

4-Material release note is required

2.0	D26801	Nut Plate
-----	--------	-----------

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D2680

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------

**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Date: Tuesday, 15/11/2005 8:05:00 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 24203

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

MS20426AD33

Rivet

9.0

MS21069L4

Nutplate

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Install Nut Plate as per Dwg D2680

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion

